

Date: Tuesday, 8/1/2006 11:31:23 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: OUTER FWD SADDLE	
Job Number	: 28079		Part Number	: D5951	
Estimate Number	: 11076		Drawing Number	: D5951 REV A	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 8/1/2006 S.O. No. N/A		Drawing Revision	: A	
Prsh Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 8/31/2006 Qty: 4 Um: Each	
Previous Run	: N/A				
Written By	: <i>[Signature]</i>				
Checked & Approved By	: <i>[Signature]</i> 06-08-01				
Comment	: Est Rev:E Re-Format 05-11-29 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D6101013	Saddle billet
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) D6101-013 (7075-T7351) Size 2.50" x 10.10" X 8.25" (Grain along 10.10") Batch: <i>28079</i> B25356 x4 En 06/11/03
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3
		Comment: HAAS CNC VERTICAL MACHINING #3 1-Machine as per folio D5951, Ensure Batch Number is entered <i>N/A</i> <i>B28079</i>
		2-Machine Keyway P10
		3-Deburr & Tumble
3.0	QC1	INSPECT ALL DIM TO DIM SHEET
		Comment: INSPECT ALL DIM TO DIM SHEET <i>5.6 En 06/11/03 4</i>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>SD 06.11.06 4</i>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>AM 06/11/08 x 4</i>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
06.11.03	2	CHAMFER 0.033 x 45° WAS ADDED AND CALLED ⑤. SIMILAR TO D2571. SEE ATTACHED	PH 06.11.03					

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes

No

DQA:

Date: 06/11/13

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

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Drawing Name: OUTER FWD SADDLE

Job Number: 28079

Part Number: D5951

Job Number:



Seq. #:	Machine Or Operation:	Description :
6.0	POWDER COATING	POWDER COATING
	Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	FC 06 11 11 (4)
7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	PC 6/11/13 (4)
8.0	PACKAGING 1	PACKAGING RESOURCE #1
	Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____	PC 6/11/13 (4)
9.0	DC	DOCUMENT CONTROL
	Comment: DOCUMENT CONTROL Inspection Level 21	DC 06/11/13 (4)

Job Completion



Local 11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	28079
Description: Outer Fwd Saddle		Part Number:	D5951
Inspection Dwg: D5951 Rev. A		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D5951 Rev. A and record below:

				Recorded Actual Dimensions						
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date	
A	0.438	0.443	-DT8682	0.440	0.440	0.440	0.440			
B	1.745	1.755		1.749	1.747	1.747	1.747			
C	5.245	5.255		5.249	5.250	5.249	5.248			
D	6.995	7.005		7.002	7.001	7.000	7.002			
E	5.745	5.755		5.751	5.748	5.751	5.751			
F	4.745	4.755		4.746	4.747	4.746	4.746			
G	0.313	0.318	-DT8686	0.315	0.315	0.315	0.315			
H	1.522	1.532		1.527	1.524	1.526	1.525			
I	3.048	3.058		3.052	3.054	3.054	3.053			
J	4.575	4.585		4.577	4.580	4.581	4.581			
K	0.313	0.318	-DT8686	0.315	0.315	0.315	0.315			
L	0.240	0.260		0.256	0.251	0.256	0.257			
M	0.490	0.510		0.505	0.503	0.504	0.505			
N	0.240	0.260		0.255	0.251	0.256	0.257			
O	7.990	8.010		8.001	8.000	8.005	8.005			
P	0.240	0.260		0.255	0.256	0.255	0.257			
Q	0.307	0.312		0.309	0.310	0.311	0.311			
R	0.760	0.765		0.765	0.765	0.765	0.765			
S	0.490	0.510		0.491	0.500	0.504	0.503			
T	1.375	1.395		1.383	1.383	1.384	1.385			
U	2.000	2.020		2.003	2.003	2.004	2.004			
V	0.023	0.043		0.030	0.030	0.030	0.030			
W	0.023	0.043								
X										
Y										
Z										
AA										
AB										
AC										
AD										
AE										
AF										
AG										
AH										
Accept/Reject										

Measured by:	EP / 3.6	Audited by:	SD
Date:	06/16/03	Date:	06.11.06

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686	KJ/RF	#

DART

DA COPY IS
DRAFT

DESIGN <i>BW</i>	DRAWN BY <i>BW</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>DMY</i>	APPROVED <i>BW</i>	DRAWING NO. D5951	REV. A SHEET 1 OF 1
DATE 97.05.06		TITLE OUTER FWD SADDLE	SCALE

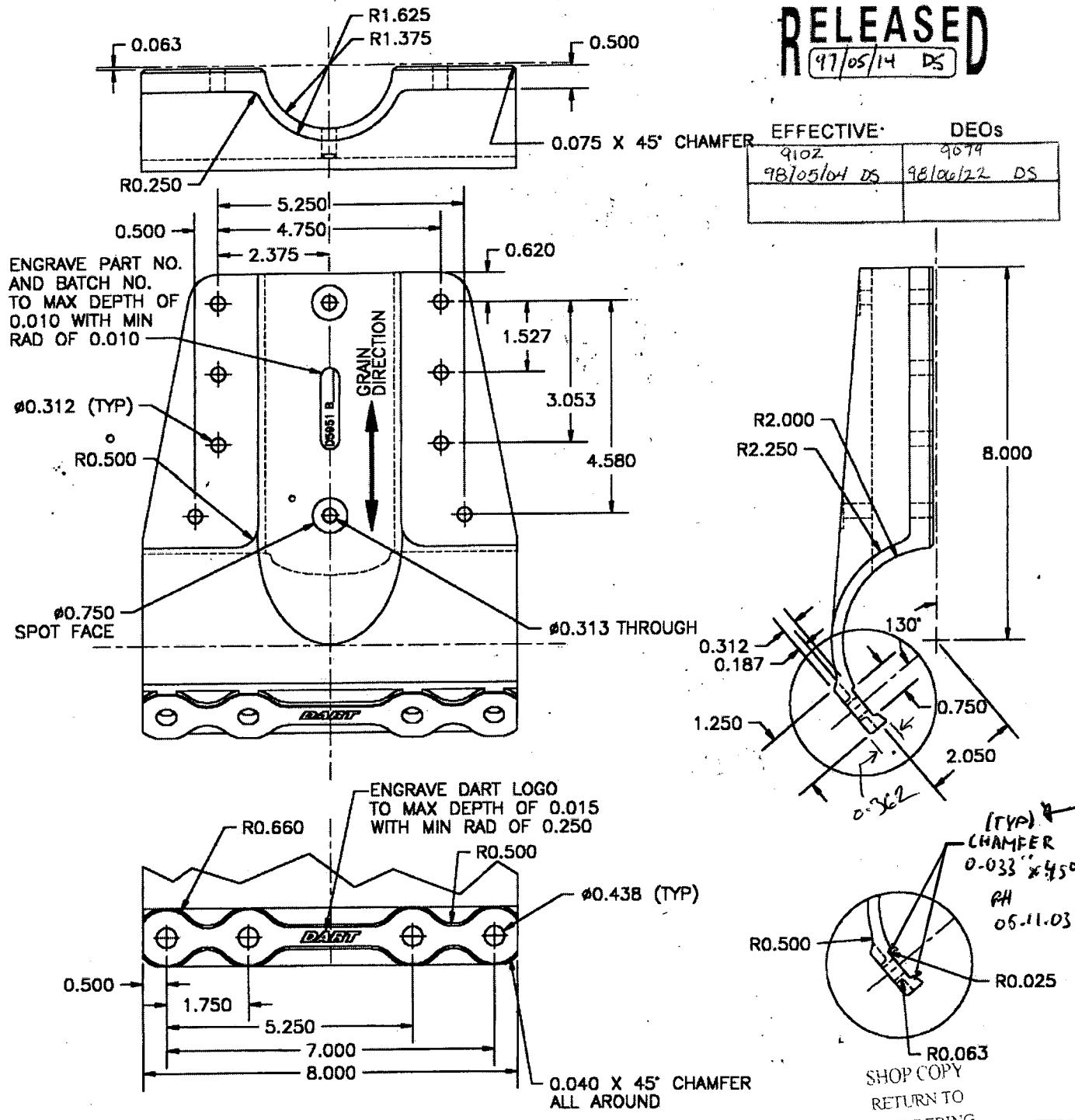
00.05.05 (P 00.05.05

MATERIAL: 7075-T651 OR 7075-T7351 QQ-A-250/12

FINISH: ACID ETCH, ALODINE PER QSI 005 4.1

PRIME, PAINT HI GLOSS WHITE (EXCEPT BORES) PER QSI 005 4.2

BREAK ALL SHARP EDGES 0.010 TO 0.020



Peter Hum

From: David Shepherd [dshepherd@dartaero.com]
Sent: November 3, 2006 10:22 AM
To: 'Peter Hum'
Subject: RE: D5951/D5953/D5955/D5957

This change is acceptable to me.

David

From: Peter Hum [mailto:phum@dartaero.com]
Sent: Thursday, November 02, 2006 2:33 PM
To: 'David Shepherd'
Subject: D5951/D5953/D5955/D5957

David,

Last year we made a change to the ridges on the 205 saddles (we made a 0.033" X 45 degree chamfer) which I've attached.

Production is making a run of the extended high gear saddles D5951/D5953/D5955/D5957. Can the changes made to the 205 saddles be applied to the x-tended high gear saddles?

The extended high gear goes onto the same D205-634 skidtubes

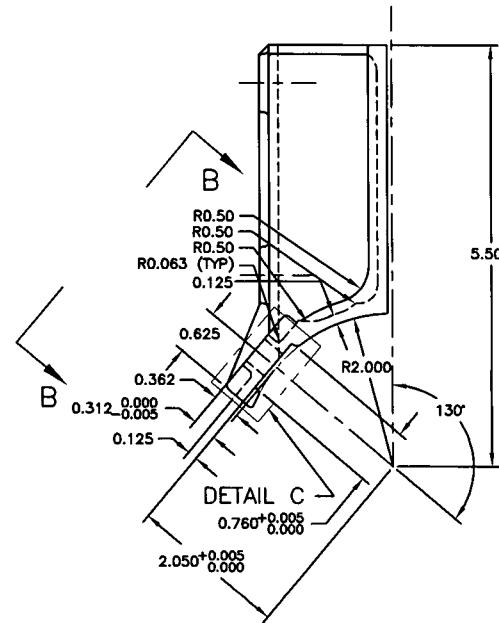
Chris Bell is currently updating the D5951/D5953/D5955/D5957 saddles and if this change is acceptable, we will add it in

Peter

--
No virus found in this incoming message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

--
No virus found in this outgoing message.
Checked by AVG Free Edition.
Version: 7.1.409 / Virus Database: 268.13.23/513 - Release Date: 11/2/2006

REFERENCE ONLY

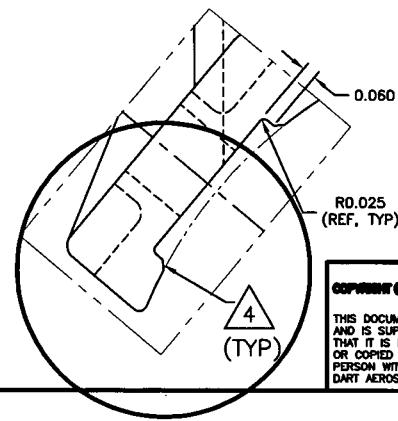


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

REFERENCE ONLY



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DESIGN	DRAWN BY	DART AEROSPACE LTD.	
DS	PH	HANSCOMB, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. E
		D2574	SHEET 1 OF 1
DATE	TITLE	SCALE	
05.07.13	INNER AFT SADDLE	2:3	